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RBE-350HYD Job Sheet 194520



Part No: RBE-350HYD

Job Qty: 6 pcs

Part Name: Hydraulic Accumulator Fitting Gauge



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/3/19

Job Tracking No:

Due Date: 6/14/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE-350HYD REV:2 IPP REV:A 18.01.16 NEW ISSUE RQ VERIFIED BY: DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	6 pcs	6/14/19		0.08	0.50	Small Fab - 1		MLC
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	6 pcs	6/14/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	6 pcs	6/14/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS 40 JUN 04 2019 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



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Container No: S187210



Part: RBE-350HYD

Job No: 194520

Serial No/Batch: S187210

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 06/04/19

				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	Dava
140 QC 21 - FG	6 pcs	6/14/19	0.00 0.00	QC 21 - FG - 21	DAS
				QC 21 - FG - 70	21 JUN 05 2019
				QC 21 - SA - 53	P-69

GA 144A

Part Op 100 - 1- Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG. 2- Assemble as per dwg.
 Descriptions: 3- Assemble using permatex thread sealant or equivalent as per note 2
 110 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____), Identify and Stock
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
4053K751	Pressure Gauge, 0-300 Psi	6 Ea (1 ea)	100-Small Fab - 1	5180821
AMF556	Bleeder Valve	6 Ea (1 ea)	100-Small Fab - 1	5175367
PAR211P-4	1/4 NPT Square Plug	6 Ea (1 ea)	100-Small Fab - 1	215084300 5X 5185400
PAR2203P-4	1/4 NPT Female "T" Fitting	6 Ea (1 ea)	100-Small Fab - 1	1X 5066111 4X 5172283
PAR209-4-2	1/4 NPT to 1/8 NPT Reducer Fitting	6 Ea (1 ea)	100-Small Fab - 1	1X 5066111 6X 5185380

21 5185413

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	4053K751	6	4	0
	AMF556	6	12	0
	PAR209-4-2	6	10	0
	PAR211P-4	6	2	0
	PAR2203P-4	6	5	0

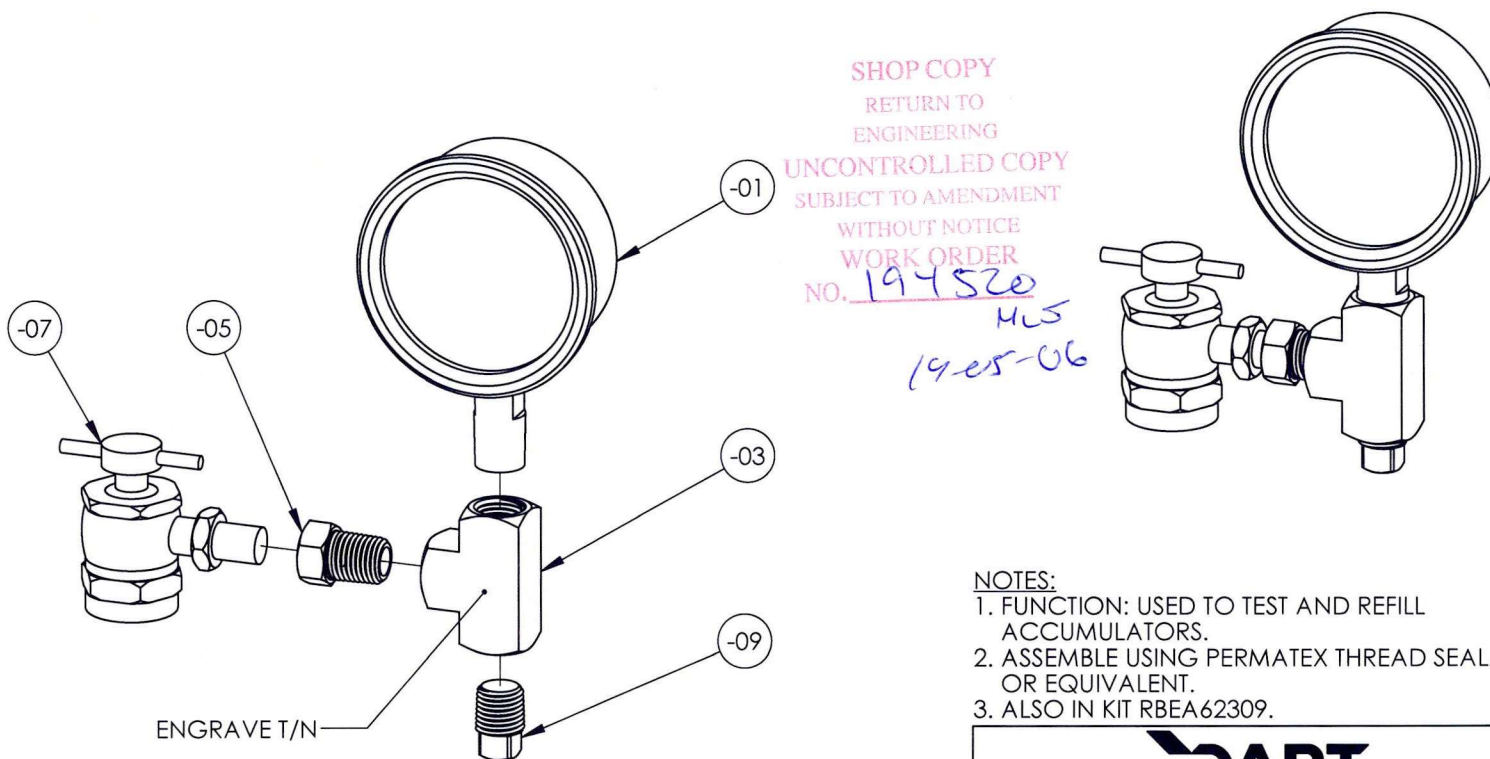
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Part Specifications

Specifications could not be found.

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		DESIGNED PER HELI PRODUCTS TOOLS.	9/28/2009	WP	DW
1A		ADDED NOTE 2 TO USE PERMATEx THREAD SEALANT PER D.W.	5/9/2012	RJC	DW
1B		-01 CH'D GAUGE WAS PACIFIC RUBBER #W1K9692040 IS PARAMOUNT SUPPLY #ASHCROFT 1008.	3/24/2014	RJC	RW
1C	14-0213	CH'D TITLEBLOCK WAS RED BARN IS DART. RE-DRAWN IN SOLIDWORKS. ADDED ENGRAVE T/N NOTE. -01 CH'D B/O INFO WAS #ASHCROFT 1008 IS #63-1008-S-02L-300#-XLL.	11/12/2014	DPD	JAG
2	16-0145	-01 CH'D B/O REF WAS PARAMOUNT SUPPLY #63-1008-S-02L-300#-XLL IS MCMaster-CARR #4053K751.	9/12/2016	DPD	JAG



NOTES:

1. FUNCTION: USED TO TEST AND REFILL ACCUMULATORS.
2. ASSEMBLE USING PERMATEx THREAD SEALANT OR EQUIVALENT.
3. ALSO IN KIT RBEA62309.

DART AEROSPACE	
TITLE HYD. ACCUM. FITTING GAUGE	
DWG NO. RBE-350HYD	REV 2
MAT'L HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: PERRITT	USED ON MODEL EUROCOPTER AS350/355
CHECKED: MACKOVJAK	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:2	DATE 9/9/2009
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
		B/O	-01	1	PRESSURE GAUGE, 0-300 PSI		0-300 psi (0-2,000 kPa) (MCMaster-CARR #4053K751)	1
		B/O	-03	1	1/4 NPT FEMALE "T" FITTING	BRASS	(PACIFIC RUBBER #PAR2203P-4)	1
		B/O	-05	1	1/4 NPT TO 1/8 NPT REDUCER FITTING	BRASS	(PACIFIC RUBBER #PAR209-4-2)	1
		B/O	-07	1	SCHRADER VALVE	S.S.	(PACIFIC RUBBER #AMF556)	1
		B/O	-09	1	1/4 NPT SQUARE PLUG	BRASS	(PACIFIC RUBBER #PAR211P-4)	1

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					